

Work Order ID 73159

Friday, August 26, 2011 7:10:37 AM



Page 1

Item ID: D3758-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: *WKF*Date: *11.08.29*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3758	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3758-1 ☐ Dwg Rev: *A* ☐ Prog Rev: *A* ☐ 2-
Deburr if necessary*304.032**1311-8-30*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1311-8-30

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/10/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00				(20)			
Small Fab	1- Deburr any rough edges 2- Form as per Dwg D3758								
				SB 11/09/15					
140 	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00				counts (20)			
Quality Control									
150 	Small Fab	0.00							
Small Fab	Memo	0.00				(20)			
Small Fab	Assemble rubber cushion as per dwg D3758								
				SB 11/09/15					

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Item Name: Clamp

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Start Date: 8/26/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 9/9/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S. Walker

counts
(20)

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: *081*

0.00

Memo

0.00

P. 6/9/10 (20)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/10

MF
11-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Friday, August 26, 2011 7:10:34 AM

Page 1

Work Order ID: 73159

Parent Item: D3758-041

Parent Item Name: Clamp



Start Date: 8/26/2011

Required Date: 9/9/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A new issue 08-05-26 DD verified by:EC
IPP Rev:B 08-10-20 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2182B028 Rubber Cushion		Manufactured	No			100	Each	0.0000	1	6			
M304S22GA 304/316 .032 Sheet		Purchased	No			150	sf	141.3600	0.026	0.164211			

B66063

20

SB 4/6/15

B 11-830

Location

Loc Qty

Loc Code

020

4.3

109057

4.3

MAT020

137.06

117379

33.56

118271

96

118400

7.5

117379

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

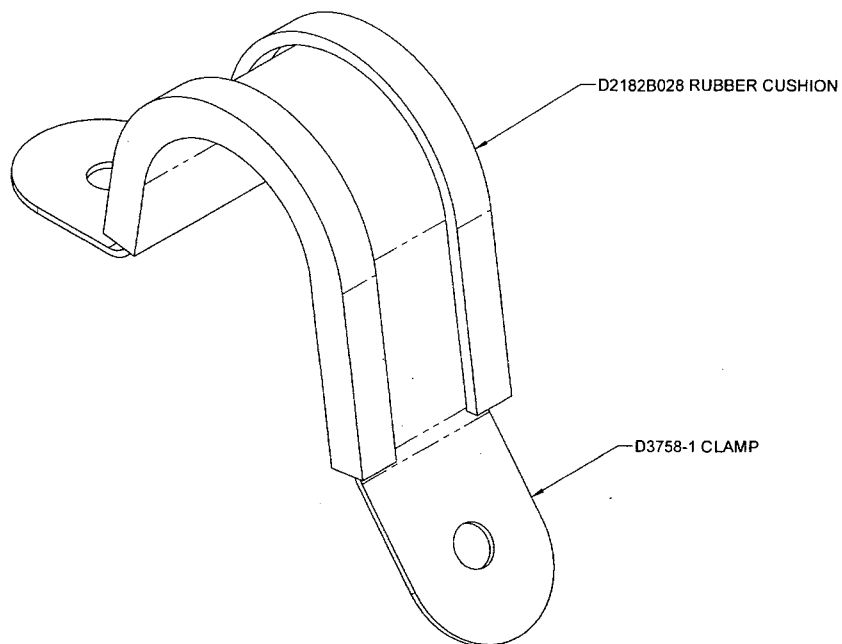
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QTY	P/N	DESCRIPTION
041		
X	D3758-041	CLAMP
1	D3758-1	CLAMP
1	D2182B028	RUBBER CUSHION



D3758-041 CLAMP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.25		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3758	REV. A SHEET 1 OF 3
TITLE CLAMP	SCALE NTS
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73159

RELEASED
08-10-15-16

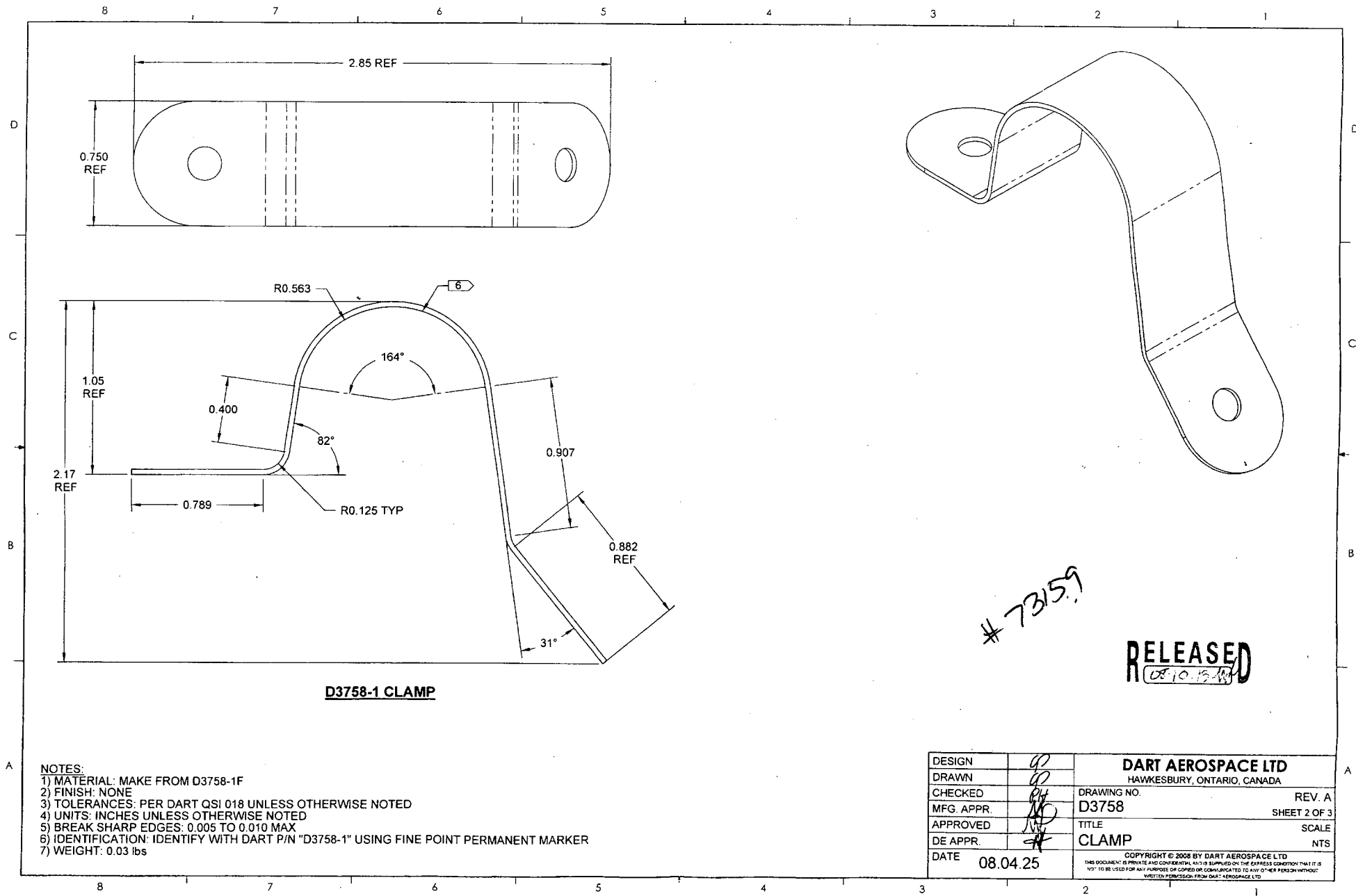
W/O:		WORK ORDER CHANGES					
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73159

RELEASED
08-10-15-11

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3758	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
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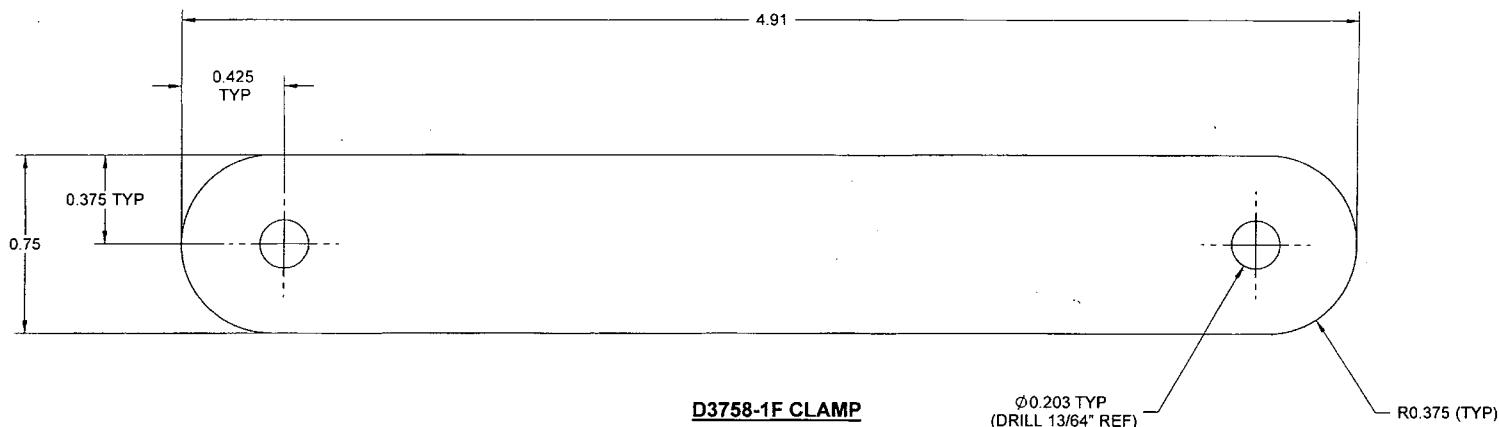
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D3758-1F CLAMP

Ø0.203 TYP
(DRILL 13/64\" REF)

R0.375 (TYP)

73159

RELEASED
08.10.15.11

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 0.031 THICK (REF DART SPEC. M304S22GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.03 lbs

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CHECKED		DRAWING NO. D3758	REV. A
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